

Work Order ID 50210

July 10, 2009 1:18:24 PM

Ship Friday

Page 1

Item ID: D3935-1
Revision ID: A
Item Name: Pylon Protector

Accept



Setup Start
Stop



Start Date: 07/13/2009 Start Qty: 8.00
Required Date: 07/16/2009 Req'd Qty: 8.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: *mf*
QC:

Date: *09-07-10* Tooling:
Date: SPC (Y/N):

Date:

Run Start
Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

100

0.00



Waterjet
FLOW CNC Waterjet

Memo
1-Cut as per Dwg D3935
Dwg Rev: *A*
Prog Rev: *A*

2- Deburr if necessary

0.00

⇒ *ml 09 07 14* (89)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC
Quality Control

Memo

0.00

⇒ *ml 09 07 14* (89)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Setup Start



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Stop



Item Name: Pylon Protector

Start Date: 07/13/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 07/16/2009 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

140

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

⇒ 80210714

48 0

9/7/14 92 SD

09/07/15

MF 09-07-15

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Picklist Print

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Page 1

Work Order ID: 50210

Parent Item: D3935-1RevA

Parent Item Name: Pylon Protector


Comments:

Start Date: 07/13/2009

Required Date: 07/16/2009

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	1,278.050	69.5200			
												
GE PLASTICS LEXAN SHEET												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	1278.05	
103106	7.8	
105330	54	
109455	0.03	
111710	1216.22	

h.m 09 07 14

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DART AEROSPACE LTD		Work Order: 50210.
Description: Pylon Wall Protector, LH		Part Number: D3935-1
Inspection Dwg: D3935	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
8.05	+/-0.030	8.05	✓		M.T	
15.05	+/-0.030	15.05	✓		M.T	
19.00	+/-0.030	19.00	✓		M.T	
19.25	+/-0.030	19.25	✓		M.T	
20.25	+/-0.030	20.25	✓		M.T	
23.25	+/-0.030	23.25	✓		M.T	
24.35	+/-0.030	24.35	✓		M.T	
29.25	+/-0.030	29.25	✓		M.T	
32.75	+/-0.030	32.75	✓		M.T	
1.00	+/-0.030	1.00	✓		M.T	
3.50	+/-0.030	3.50	✓		M.T	
9.00	+/-0.030	9.00	✓		M.T	
17.00	+/-0.030	17.00	✓		M.T	
18.50	+/-0.030	18.50	✓		M.T	
33.40	+/-0.030	33.40	✓		M.T	
34.25	+/-0.030	34.25	✓		M.T	
34.60	+/-0.030	34.60	✓		M.T	
34.72	+/-0.030	34.72	✓		M.T	
22.85	+/-0.030	22.85	✓		M.T	
19.15	+/-0.030	19.15	✓		M.T	
35.39	+/-0.030	35.39	✓		M.T	
0125	+/-0.010	0.129	✓		VEN	

Measured by: M.M.	Audited by: S	Prototype Approval:	N/A
Date: 09.07.14	Date: 09/07/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.06.22	New Issue	KJ	

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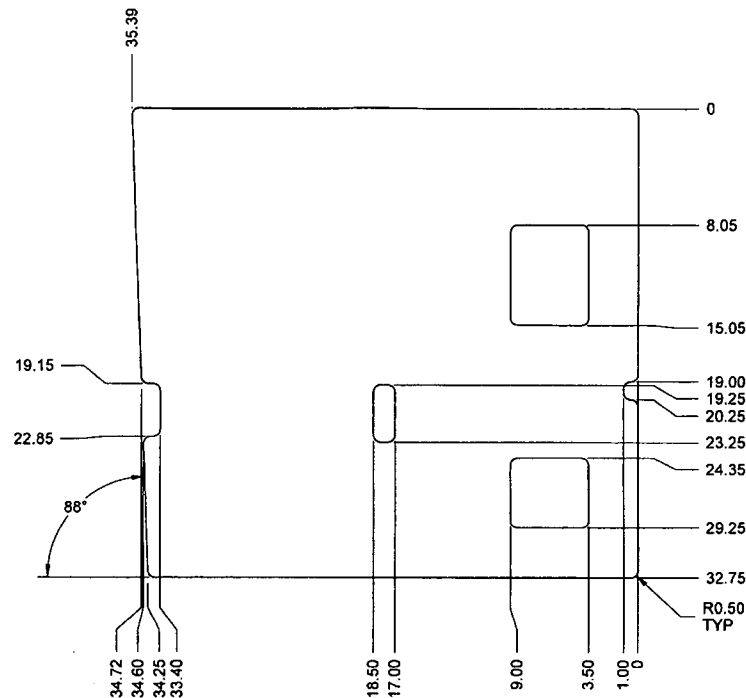
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SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 50216

MF 09-07-10



D3935-1 PYLON WALL PROTECTOR, LH
(TEXTURED SIDE SHOWN)

RELEASED
09/06/07

NOTES:

- 1) MATERIAL: F60029-GY3778 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125 THICK
REF DART SPEC MLEXS.125-F60029-04
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3935-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 5.79 lbs
- 8) CHECK PER TEMPLATE DT8922

A		NEW ISSUE		09.04.21	
REV.	DESCRIPTION	BY	DATE		
DESIGN				DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN					
CHECKED				DRAWING NO.	REV. A
MFG. APPR.				D3935	SHEET 1 OF 2
APPROVED				TITLE	SCALE
DE APPR.				PYLON PROTECTOR	NTS
DATE	09.04.21				

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